

Date: Monday, 18/08/2008 3:43:53 PM
 User: Julie Lecocq

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: FWD BLADE FOLD ASSY WELDMENT
Job Number	: 41362		
Estimate Number	: 13418		
P.O. Number	:	Part Number	: PB674300107
This Issue	: 18/08/2008 S.O. No. :	Drawing Number	: B6743001 P.5
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: / / Type : LARGE FAB ASSY	Drawing Revision	: B1
Previous Run	: 40771	Material	:
Written By	:	Due Date	: 18/09/2008 Qty: 8 Um: Each
Checked & Approved By	: <u>Jul 08.8.18</u>		
Comment	: Est Rev:A 08-06-25 new issue DD verified by:ec		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	PB674300147	Base Assembly
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 8.0000 Each(s)

Base Assembly

batch: B41509Ppl 08.10.20

2.0	PB6743001205	Outer Tube
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 8.0000 Each(s)

Outer Tube

batch: B41485Ppl 08.10.20

3.0	PB6743001197	Outer Tube
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 8.0000 Each(s)

Outer Tube

batch: B41483Ppl 08.10.20

4.0	PB6743001211	Square Tubing
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Comment: Qty.: 6.0000 Each(s)/Unit Total: 48.0000 Each(s)

Square Tubing

batch: B41487 *Ppl 08.10.20

5.0	PB6743001209	Square Tubing
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 8.0000 Each(s)

Square Tubing

batch: B41486Ppl 08.10.20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FWD BLADE FOLD ASSY WELDMENT

Job Number: 41362

Part Number: PB674300107

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

PB6743001201

Square Tubing



Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s)
Square Tubing
batch:- B40592

Cpl 08-10-20

7.0

PB6743001203

Square Tube



Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s)
Square Tube
batch:- B41789

Cpl 08-10-20

8.0

PB6743001207

Square Tube



Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s)
Square Tube
batch:- B40593 → 1 42603x1 ~~B41204~~

Cpl 08-10-20

9.0

PB6743001219

Angled Male Eye



Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s)
Angled Male Eye
batch:- 40041

Cpl 08-10-20

10.0

D34405

Contoured Detent Clip Base



Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s)
Contoured Detent Clip Base
batch:- B41203

Cpl 08-10-20

11.0

D34407

Detent Clip Base



Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s)
Detent Clip Base
batch:- B23735 → 1 B41204 → 1

Cpl 08-10-20

** gone to Lalaland
→ shows pulled
in Accpac not
cost*

12.0

D344015

Contoured Male Eye



Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s)
Contoured Male Eye
batch:- B41202

Cpl 08-10-20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Job Number:



Seq. #: Machine Or Operation: Description :

13.0 LARGE FAB 1 LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1- assemble parts on jig DT8813 and weld as per dwg PB67-43001

*** ensure no burn thru after welding in tube -205 and -197 only where bushing -265 ***

Plor 10-20 **(+2)**

14.0 QC9 VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

12/08/21 **(2)**

15.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

20/08/21 **(+2)**

16.0 POWDER COATING POWDER COATING



Comment: POWDER COATING

mask inside of D3440-5, D3440-7 and D3440-15 prior to paint*

Powder Coat Green Sandtex (Ref: 4.3.5.8) as per QSI 005 4.3

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

11:00
320°F
11:30

M-1 *08/10/21*

(2X)

17.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

FL *08/10/21* **(2)**

18.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

Assy PB6743001-01 B41290

19.0 QC21 FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/10/21 **(2)**

Job Completion



MF *08-10-21*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

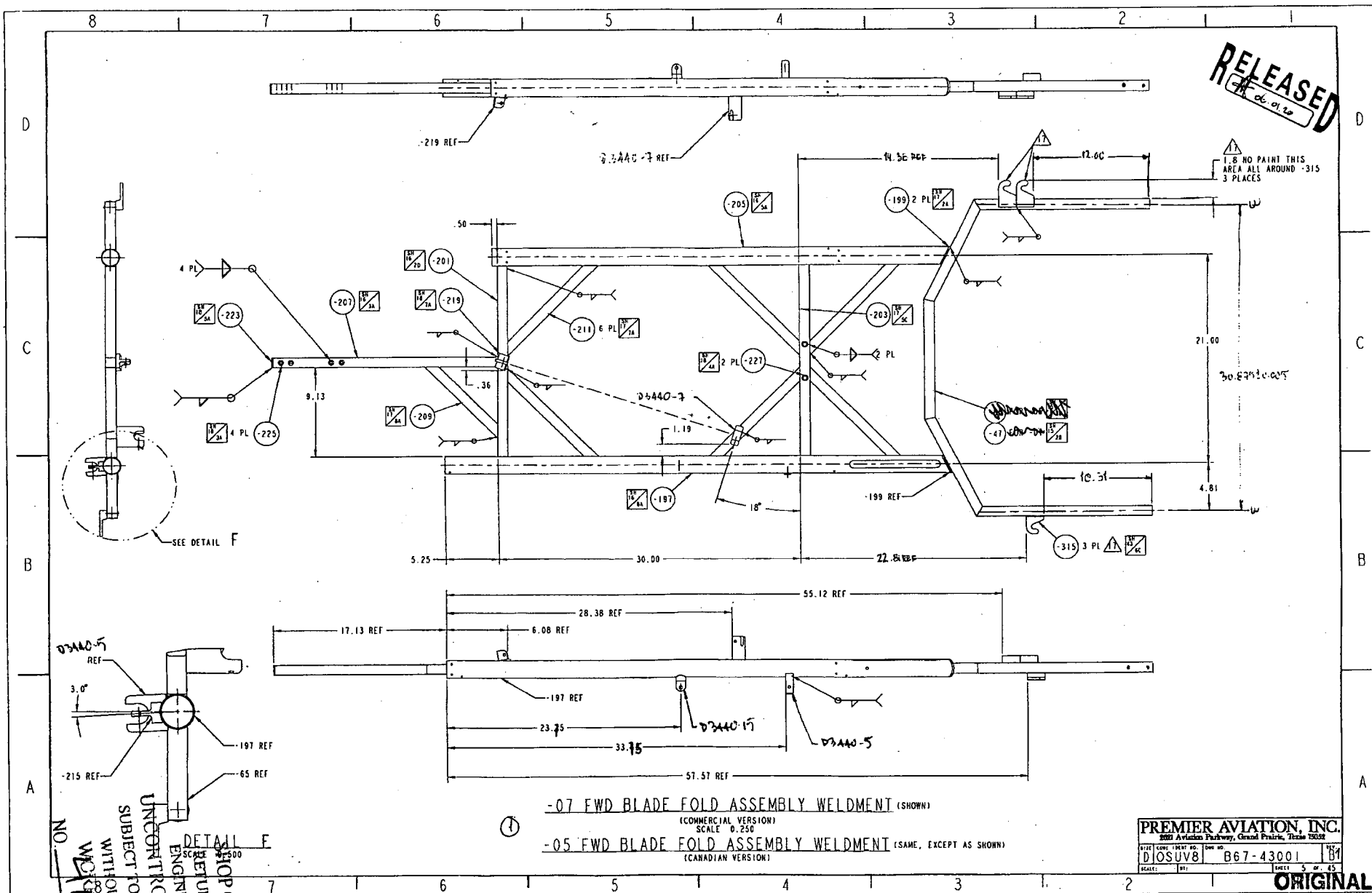
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

RELEASED
06-01-20



ORIGINAL